

ASAP

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:35:19 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 47024	
<b>Estimate Number</b> : 13310	
<b>P.O. Number</b> :	<b>Part Number</b> : D37931
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3793 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45354	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/04/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JUD 09.04.07	
<b>Comment</b> : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.6197 sf(s)/Unit Total : 12.3942 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 110072

M 09 04 08 (20)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3793  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

M 09 04 08 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M 09 04 08

(20)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/04/09 counter (20)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

E 09/04/09 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:35:19 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47024

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/09 (20)  
S 09/04/09 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

12:30

OVEN TEMPERATURE:

320°

FINISH TIME:

1:00

FL 09/04/09

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-9 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-18

BR 09-04-9 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



MF  
09-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47024
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3793-1
<b>Inspection Dwg:</b> D3793	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

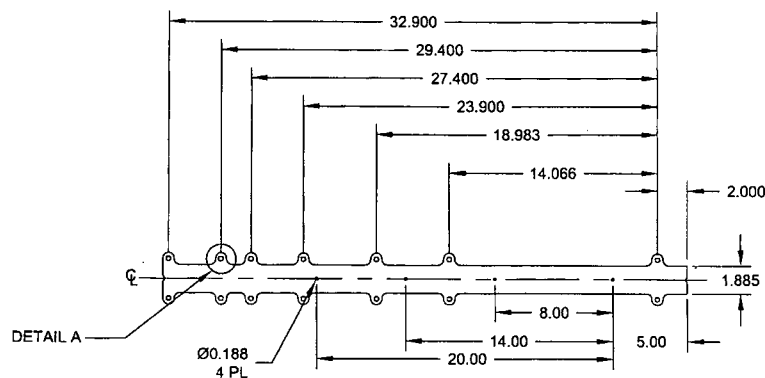
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.188	✓		VERN	
0.300 x 0.300	+/-0.010	0.300(x2)	✓		VERN	
1.885	+/-0.010	1.891	✓		VERN	
2.000	+/-0.010	2.000	✓		M.T	
5.00	+/-0.030	5.00	✓		M.T	
8.00	+/-0.030	8.00	✓		M.T	
14.00	+/-0.030	14.00	✓		M.T	
20.00	+/-0.030	20.00	✓		M.T	
14.066	+/-0.010	14.066	✓		M.T	
18.983	+/-0.010	18.983	✓		M.T	
23.900	+/-0.010	23.900	✓		M.T	
27.400	+/-0.010	27.400	✓		M.T	
29.400	+/-0.010	29.400	✓		M.T	
32.900	+/-0.010	32.900	✓		M.T	
0.040	+/-0.010	0.039	✓		VERN	

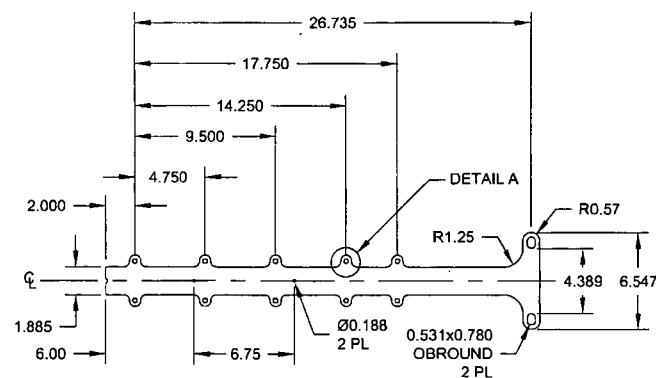
<b>Measured by:</b> M.M	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09.04.08	<b>Date:</b> 09/04/09	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

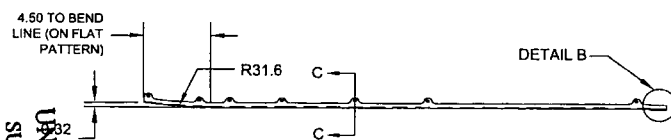
8 7 6 5 4 3 2 1



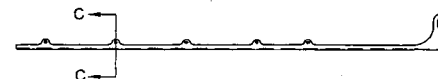
**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
26.05.25/14

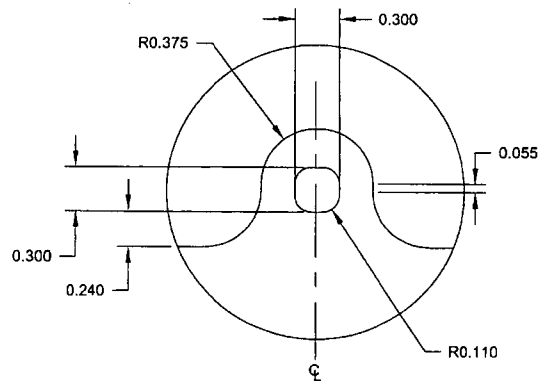
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "XXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

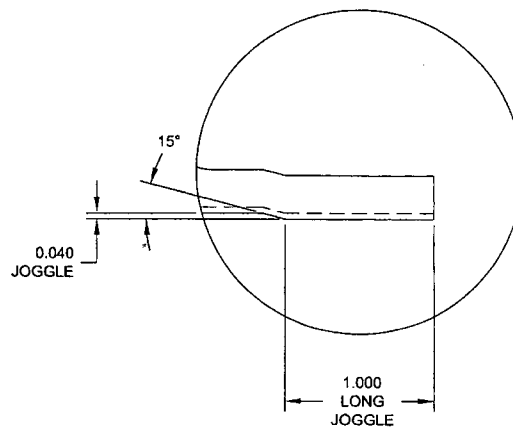
REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	BY	DATE
DRAWN	PH	<b>PORT HADLOCK, WA</b>		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3793		SHEET 1 OF 2
APPROVED		TITLE	SCALE	
DE APPR.		WEARSHOE	NTS	
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC		

8 7 6 5 4 3 2 1

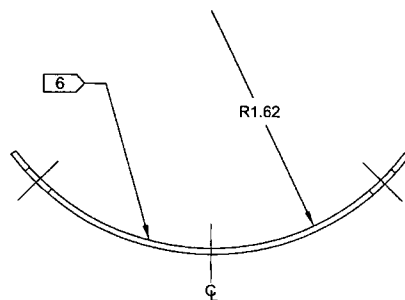
8 7 6 5 4 3 2 1



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-13 N/A

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CHECKED	PH	DRAWING NO.	REV. A
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DE APPR.	PH	WEARSHOE	NTS
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8 7 6 5 4 3 2 1